

Work Order ID 125064

Tuesday, October 07, 2014 10:34:23 AM

125064

Page 1

Item ID: D500-572-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 9/24/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-10-07 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1
IIND500-572	RevA

100 Document Control 0.00
DOCUMENT CONTROL

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and create labels per PPP D500-572-011 CHG005

DAS

38

9-89

14-11-10

160 Pick Kit 0.00

160

Packaging

Packaging

Memo

0.00

DAS

31

9-89

DAS

31

9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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125064

Page 2

Tuesday, October 07, 2014 10:34:23 AM

Item ID: D500-572-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 9/24/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.00							DAS 38 9-89
170						1			14-11-10
QC	Memo	0.00							
Quality Control									
180		0.00							DAS 86 9-89
180	Packaging					1			NOV 10 2014
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD500-572-011 Location: <u>P6012</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									14/11/11 DJ
QC	Memo	0.00							
Quality Control									

14-11-10

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:34:22 AM

Page 1

Work Order ID: 125064

125064

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C04.02.17Blank size changedKJ/JLM
 IPP Rev:D 07-01-02 Was K10007 JLM
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-15A		Purchased	No				Each	526.0000	8	8			
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AN4-15A
 Bolt
 DAS
 38
 9-89

**

Location	Loc Qty	Loc Code
GA	100	
120449	100	
ST343	400	
m129732	200	
m130358	200	
ST357	11	
m127817	11	
ST515	15	
122141	4	
m123525	6	
m128978	5	

DAS
 38
 9-89

DAS
 31
 9-89

D2182B		Manufactured	No				f	286.8200	1:666	2			
--------	--	--------------	----	--	--	--	---	----------	-------	---	--	--	--

D2182B
 Seal(\$Per Foot)
 DAS
 38
 9-89

**

Location	Loc Qty	Loc Code
ST411	286.82	
101827	1	
108914	2.71	
115189	283.11	

NOV 08 2014
 DAS
 38
 9-89

DAS
 31
 9-89

4x5"

2 feet

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:34:23 AM

Page 2

Work Order ID: 125064

125064

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

D2274

DAS
38
9-89

Manufactured No

170

Each

695.0000

8 8

**

D2274

Radius Block

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST005

683

109534

6

110264

2

112466

2

115803

43

117869

357

121589

273

8

DAS
31
9-89

D2435

DAS
38
9-89

Manufactured No

170

Each

0.0000

2 2

**

D2435

Bearpaw

124387

DAS
06
9-89

DAS
31
9-89

D2438

DAS
38
9-89

Manufactured No

170

Each

88.0000

4 4

**

D2438

Clamp

DAS
06
9-89

Location

Loc Qty

Loc Code

ST542

88

112483

87

115202

1

4

NOV 08 2014

DAS
31
9-89

Tuesday, October 07, 2014 10:34:23 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

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Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:34:23 AM

Page 3

Work Order ID: 125064

125064

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

D2529

Manufactured No

170

Each

753.0000

(8) 8

**

DAS
06
9-89

D2529

DAS

Washer

38

9-89

Location

Loc Qty

Loc Code

ST007

753

109580

7

115153

45

119633

600

121250

100

56184

1

MS21042L4

Purchased

No

170

Each

3,703.000

(8) 8

**

DAS
06
9-89

MS21042L4

DAS

Locknut

38

9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

3691

111827

2

126275

5

m126015

12

m126275

27

m127255

63

m127376

9

m127813

821

m128300

69

m128798

658

m129472

525

m129934

1500

NOV 07 2014

DAS
06
9-89

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 125064

125064

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

170

Each

4,366.000

8 8

NAS1149D0463.J

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

CA	472	
M129682	472	
ST277	3894	
16941	8	
M126221	20	
M127813	6	
M127904	16	
M128591	44	
M128995	1500	
M129390	2300	

**

DAS
30
9-89

DAS
31
9-89

QS200-M44S

Purchased

No

120

Each

45.0000

2 2

QS200-M44S

CLAMP

DAS
38
9-89

Location

Loc Qty

Loc Code

ST545	45	
m128813	15	
m129499	30	

**

DAS
30
9-89

NOV 07 2014

DAS
31
9-89

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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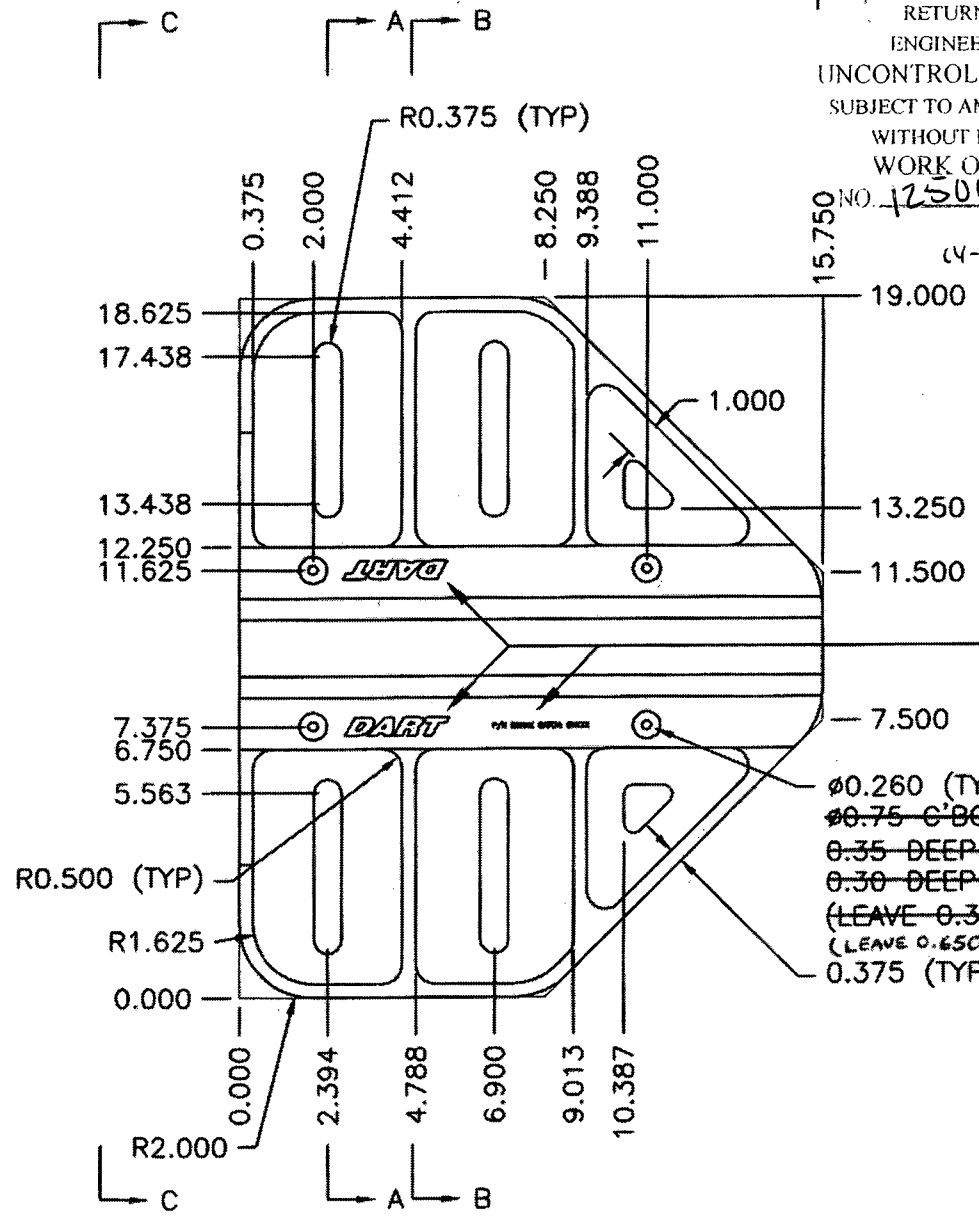


RELEASED
98.06.17 KE

E1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ REA
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 125064
ML3
14-10-07

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 ~~$\phi 0.75$ C'BORE~~ 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM.
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)



9143	

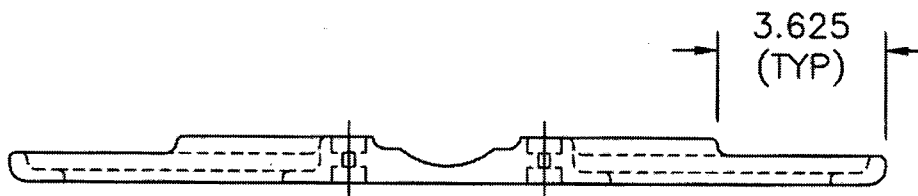
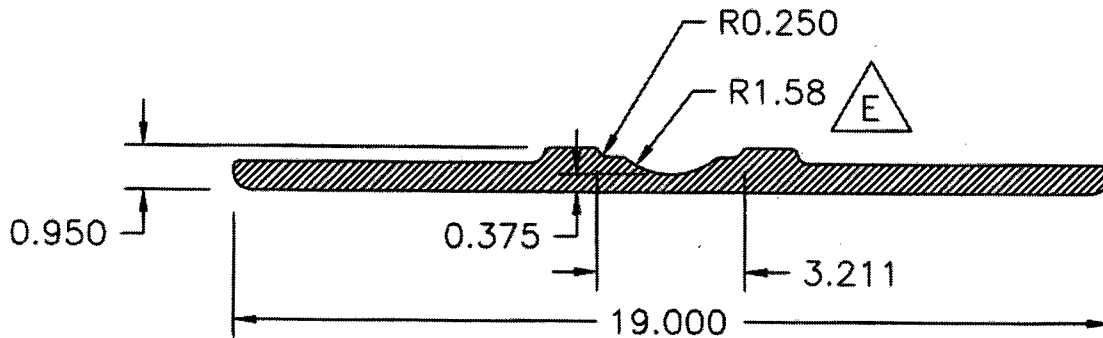
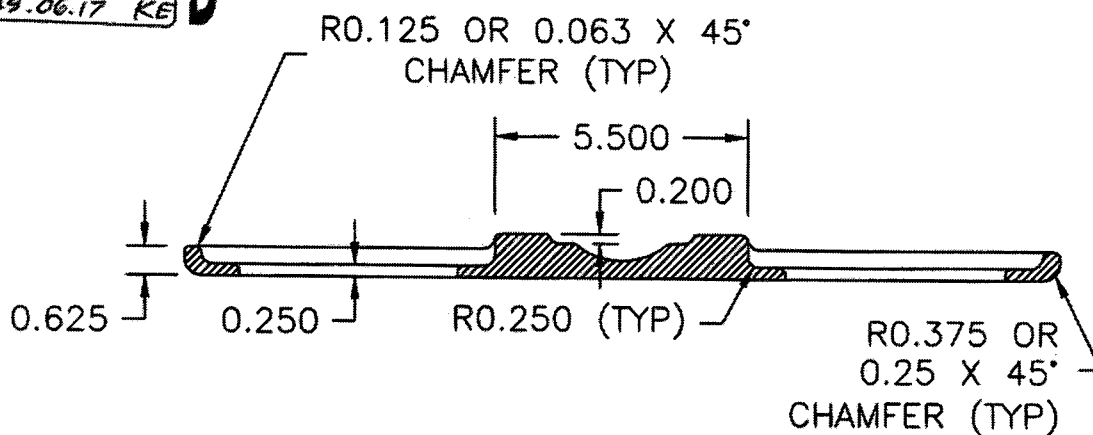
DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	REV. E
98.05.19	BEARPAW	SHEET 1 OF 2
		SCALE
		1:5
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DM</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



Work Order ID 125064

125064

Page 1

Tuesday, October 07, 2014 10:34:23 AM

Item ID: D500-572-011 Accept ***N900040100*** Setup Start ***NS1***

Revision ID: Stop ***NS2***

Item Name: Bearpaw

Start Date: 9/24/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: MLJ Date: 14-10-07 Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								
IIND500-572	RevA								

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D500-572-011 CHG005

MLJ 14-11-10

160 Pick Kit 0.00
160
 Packaging Memo 0.00
 Packaging